

Friday, 10/13/2006 9:27:29 AM

User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : EC 135 SKIDTUBE ASSEMBLY
Job Number : 28957	
Estimate Number : 12472	
P.O. Number : N/A	Part Number : D135751011
This Issue : 10/13/2006 S.O. No. : N/A	Drawing Number : D3507 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A	Drawing Revision : A
Previous Run : 28956	Material : N/A
	Due Date : 11/15/2006
Written By : <u> </u>	Qty: 1 Um: Each
Checked & Approved By : <u> </u>	
Comment : Est Rev: A 06-06-21 New Issue JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP D135-751-011 CHG001

CL KS 0610.23 ①

2.0	D2962150	3.540 Outer Tube, Extrud
-----	----------	--------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2962-150	Extrusion	

B227774

DP

6-10-20

3.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
-----	----------------	-------------------------



Comment: LANDING GEAR RESOURCE 1

1-Determine square end of tube and deburr

2-Drill #30 pilot holes using DT8678. Do not open holes.

3- Deburr holes.

N/A

4.0	BENDING	BENDING MACHINE
-----	---------	-----------------



Comment: BENDING MACHINE

Bend tube as per program on CNC Bender and Dwg D3507. Use 5/16" locator pin on buggy "A".

N/A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: EC 135 SKIDTUBE ASSEMBLY

Job Number: 28957

Part Number: D135751011

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Cut Fwd end of the tube using DT8185 ✓

2-Cut Aft end at VC using DT8185 ✓

3-Deburr ends ✓

4-Drill Aft & Fwd Cap holes using DT8678

5-Locate DT8870 & Drill Ground wire hole on top of Tube. ✓

6-Locate DT8870 with 3/16" cleco in Ground wire hole, then Pilot Drill all X-Bolt holes using 3/16" drill.

do not open AFT Cap holes
 7-Open Aft & Fwd Cap holes using .208" drill.

7-Drill pilot holes for wearplates using Dt8868

8-Open wearplate holes to Ø19/64" (0.297") as per Dwg D3507.

10- Bore out aft end of tube as per Dwg D3507 & Detail "B".
 11- 11-Deburr holes.

open 6 AFT wearplate holes
 using DT8892 open to Ø19/64"

G-10-20

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

PH 06/10/26

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M.B 06/10/26 ①

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Pm 06-11-①②

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: EC 135 SKIDTUBE ASSEMBLY

Job Number: 28957

Part Number: D135751011

Job Number:



Seq. #:

Machine Or Operation:

Description :

9.0

D35043

CROSSBOLT SPACER



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

CROSSBOLT SPACER

Batch: B 28034

BE 06-11-02 ①

10.0

D35041

CROSSBOLT SPACER



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

CROSSBOLT SPACER

Batch: B 28033

BE 06-11-02 ①

11.0

D35051

WEB



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

WEB

Batch: B 28962

Pm' 06-11-01 ①

12.0

D35061

DOUBLER



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

DOUBLER

Batch: B 28963

Pm' 07-03-13 ①

13.0

D35063

DOUBLER



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

DOUBLER

Batch: B 28964

Pm' 07-03-13 ①

14.0

MS20601AD4W3

Rivet



Comment: Qty.: 12.0000 Each(s)/Unit Total: 12.0000 Each(s)

Rivet

Batch: m 8325

Pm' 07-03-13 ①

15.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open X-Bolt holes to .375"(2Places) & .500"(2Places) as per Dwg D3507. and Detail "F" Pm' 06-11-01

2-Counter Sink X-BOLT holes as per Dwg D3507 Pm' 06-11-01 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

User:

Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

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Job Number: 28957

Part Number: D135751011

Job Number:



Seq. #:

Machine Or Operation:

Description:

3-Deburr and blow out chips from inside of tube.

Pm' 06-11-01 ①

4-Bond web as per Dwg D3507 & QSI 015

A/R 241 Sike Flex

Batch: m102107

Exp Date: 07-02-01

Pm' 06-11-01 ①

5-Weld x-bolt (D3504-1/-3) spacers as per Dwg D3507 and Detail C-C & D-D.

A/R AL ROD

Batch:

m101625

BE 06-11-02 ①

6-Grind welds flush

BE 06-11-02 ①

7-Drill Rivet Holes as per Dwg D3507 Using Dt8871A&B

BE 06-11-02 ①

8-Deburr Rivet holes.

BE 06-11-02 ①

Tools: E

16.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

M09/11/06 ①

17.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Rivet D3506-1/-3 as per Dwg D3507.

Pm' 07-03-13 ①

18.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

M07/03/13 ①

19.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

FEL 07/06/08 ①

20.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M07/06/12 ①

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/07/11

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
070612	25.0	1 D2965 cap required for ASS'y, and original w/o, the caps were powder coated black.	QSI042	Stand cap smooth with 320 grit, Pre-heat the D2965 cap, and powder coat white per QSI 005	07-07-08 QSI/MS	EP 07/07/08	QSI042	070612

NOTE: Date & initial all entries

Date: Monday, 12/18/2006 10:56:28 AM
User: Jean-Luc Menard

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: EC 135 SKIDTUBE ASSEMBLY

Job Number: 28957

Part Number: D135751011

Job Number:



Seq. #:

Machine Or Operation:

Description :

21.0

ALS71032130

Insert



Comment: Qty.: 38.0000 Each(s)/Unit Total : 38.0000 Each(s)

Insert

Batch: *m103495*

22.0

ALS41032225

Insert



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Insert

Batch: *m19393*

23.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Install Wearplate & Ground Wire inserts as per Dwg D3507.

SL 07/06/12 ①

24.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Inspect Inserts

m1 07 06 12

25.0

D2965

Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Cap

Batch: *B28959*

①
(P70)

on previous page.

26.0

D29653

Cap



Comment: Qty.: 1.0000 (s)/Unit Total : 1.0000 (s)

Cap

Batch: *B29993*

27.0

D35081

WEARPLATE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARPLATE

Batch: *B51195*

SL 07/06/12 ①

Date: Monday, 12/18/2006 10:56:28 AM
User: Jean-Luc Menard

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: EC 135 SKIDTUBE ASSEMBLY

Job Number: 28957

Part Number: D135751011

Job Number:



Seq. #:	Machine Or Operation:	Description :
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28.0	D35083	WEARPLATE
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
WEARPLATE
Batch: B31196

29.0	D35085	WEARPLATE
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
WEARPLATE
Batch: B31197

30.0	D35087	WEARPLATE
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
WEARPLATE
Batch: B31198

31.0	D3492041	PLUG ASSEMBLY
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
PLUG ASSEMBLY
Batch: B29983 (x2) B29797 (x2)

32.0	D3492047	PLUG ASSEMBLY
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
PLUG ASSEMBLY
Batch: B28961

33.0	AN960C10L	Washer
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Comment: Qty.: 35.0000 Each(s)/Unit Total : 35.0000 Each(s)
Washer
Batch: M103641 M104625

34.0	AN3C4A	BOLT
------	--------	------



Comment: Qty.: 31.0000 Each(s)/Unit Total : 31.0000 Each(s)
BOLT
Batch: M103641

FL 07/06/12 ①

Date: Monday, 12/18/2006 10:56:28 AM
User: Jean-Luc Menard

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: EC 135 SKIDTUBE ASSEMBLY

Job Number: 28957

Part Number: D135751011

Job Number:



Seq. #:	Machine Or Operation:	Description :
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35.0	AN3C5A	Bolt
------	--------	------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: m104118

36.0	D35581	GASKET
------	--------	--------



Comment: Qty.: 1.0000 (s)/Unit Total : 1.0000 (s)

GASKET

Batch: B29998

37.0	D35583	GASKET
------	--------	--------



Comment: Qty.: 1.0000 (s)/Unit Total : 1.0000 (s)

GASKET

Batch: B29999

38.0	D35585	GASKET
------	--------	--------



Comment: Qty.: 1.0000 (s)/Unit Total : 1.0000 (s)

GASKET

Batch: B3000

39.0	D35587	GASKET
------	--------	--------



Comment: Qty.: 1.0000 (s)/Unit Total : 1.0000 (s)

GASKET

Batch: B30001

40.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

1-Inspect for Foreign objects

2-Install Fwd & Aft caps as per Dwg D3507 And Detail "A" & "B"

A/R 241 Sika Flex Batch: m104732

Exp Date: 07/10

3-Install Wearplates as per Dwg D3507 ,seal screws with sikaflex.

Note:Install (1) srcrew and (1) washer on Ground Wire insert on top of tube

Do not Install Scews where indicated on Dwg(Note #6)

A/R 241 Sika Flex Batch: m104732

FL 07/06/26 ①

Date: Monday, 12/18/2006 10:56:28 AM
User: Jean-Luc Menard

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: EC 135 SKIDTUBE ASSEMBLY

Job Number: 28957

Part Number: D135751011

Job Number:



Seq. #:

Machine Or Operation:

Description :

Exp Date: 07/10

4-Install Plug assemblys as per Dwg D3507.

5- Wing Walk as per Dwg D3043 and QSI 005 4.4

FL 07/06/26 (1)

41.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/02/02 (4)

42.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

43.0

D35121

WEARPLATE



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

WEARPLATE

Batch: 031199 -X ✓

44.0

M627039108

AN3C4A.

~~Screw~~ Bolt.



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

~~Screw~~ Bolt.

Batch: 1104214 ✓

45.0

AN960JD10L

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Washer

Batch: 1103044 ✓

07/07/09 (1)

46.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

7/7/939 (1) 0207107110 (1)

47.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D135-751-011

Location:

PPP Rev:

DRAFT

07/11 (1) 50

Date: Monday, 12/18/2006 10:56:28 AM
User: Jean-Luc Menard

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: EC 135 SKIDTUBE ASSEMBLY

Job Number: 28957

Part Number: D135751011

Job Number:



Seq. #:

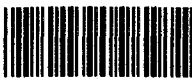
Machine Or Operation:

Description :

48.0

QC21

FINAL INSPECTION/W/O RELEASE



①

Comment: FINAL INSPECTION/W/O RELEASE

28957

Job Completion



u 28957-11

28957

NO. 71

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name B.E.

Joint Welding Procedure TIG

Part number and Job number A135751011/B28957

TEST WELDS REQUIRED

BASE METAL Alum WELDING PROCESS TIG
Penetration Complete ☐ Partial ☒ Single Weld ☒ Double Weld ☐
Current AC ☒ DC ☐ Backing YES ☐ NO ☒

	Position	Vertical	Down <input type="checkbox"/>	Up <input type="checkbox"/>
Sheet Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	3G <input type="checkbox"/>	4G <input type="checkbox"/>
Tube Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	5G <input type="checkbox"/>	6G <input type="checkbox"/>
Sheet Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	3F <input type="checkbox"/>	4F <input type="checkbox"/>
Tube Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	4F <input type="checkbox"/>	5F <input type="checkbox"/>

Crossbolt Spacer Welded into Skidtube

TEST RESULTS

Visual Pass ☒ Fail ☐

Penetration Pass ☒ Fail ☐

Crossbolt Spacer Pass ☒ Fail ☐

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

Date of Test Coupon 06/11/02

Qualifier David Dural



DESIGN PH	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED H	APPROVED H	DRAWING NO. D3507	REV. B SHEET 1 OF 2
DATE 06.11.01		TITLE EC 135 SKIDTUBE	SCALE NTS
A	06.04.21	NEW ISSUE	
B	06.11.01	ADD GASKET, CHANGE HARDWARE MAT'L	

RELEASED

06.12.12 H

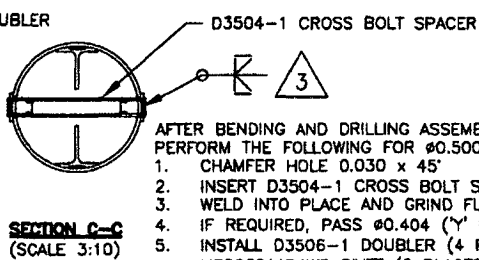
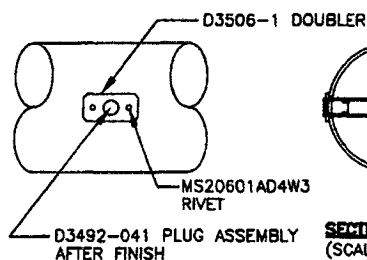
Qty	Part Number	Description
X	D3507-041	SKIDTUBE ASSEMBLY
1	D2962-150	EXTRUSION
1	D2965	CAP
1	D2965-3 ✓	CAP
4	D3492-041 ✓	PLUG ASSEMBLY
2	D3492-047 ✓	PLUG ASSEMBLY
2	D3504-1	CROSS BOLT SPACER
1	D3504-3	CROSS BOLT SPACER
1	D3505-1	WEB
4	D3506-1	DOUBLER
2	D3506-3	DOUBLER
1	D3508-1 ✓	WEARPLATE
1	D3508-3 ✓	WEARPLATE
1	D3508-5 ✓	WEARPLATE
1	D3508-7 ✓	WEARPLATE
1	D3558-1 ✓	GASKET
1	D3558-3 ✓	GASKET
1	D3558-5 ✓	GASKET
1	D3558-7 ✓	GASKET
38	AELS-1032-130 ✓	INSERT
1	AELS-1032-225 ✓	INSERT
31	AN3C4A ✓	BOLT
4	AN3C5A ✓	BOLT
35	AN960C10L ✓	WASHER
12	MS20601AD4W3 ✓	RIVET

GENERAL NOTES:

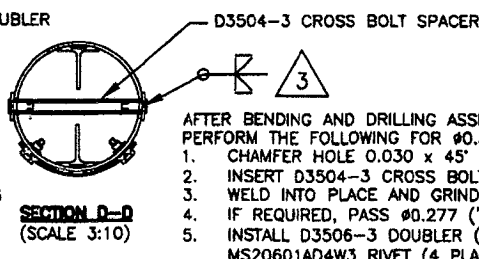
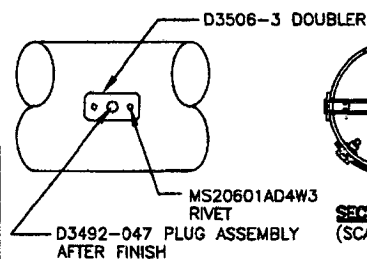
- 1) ALL DIMENSIONS ARE IN INCHES
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) WELDING TO BE DONE PER DART QSI 004.
- 4) INSERT D3505-1 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015 AFTER BENDING.
- 5) USE DART DRILL TEMPLATE DT8868 TO LOCATE AND DRILL Ø0.297 HOLES (38 PLACES) FOR WEARSHOE INSERTS. INSTALL AELS-1032-130 PER SECTION C-C (38 PLACES) AFTER FINISH. SEAL WEARPLATE SCREWS WITH SIKAFLEX-241/-291.
- 6) DO NOT INSTALL AN3C4A BOLTS AND AN960C10L WASHERS IN INDICATED LOCATIONS.
- 7) FINISH:
CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSERTING D3505-1 WEB. POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3. ANTI-SKID PAINT AS INDICATED TO 1.00 ABOVE CENTER LINE PER DART QSI 005 4.4 (OPTIONAL)

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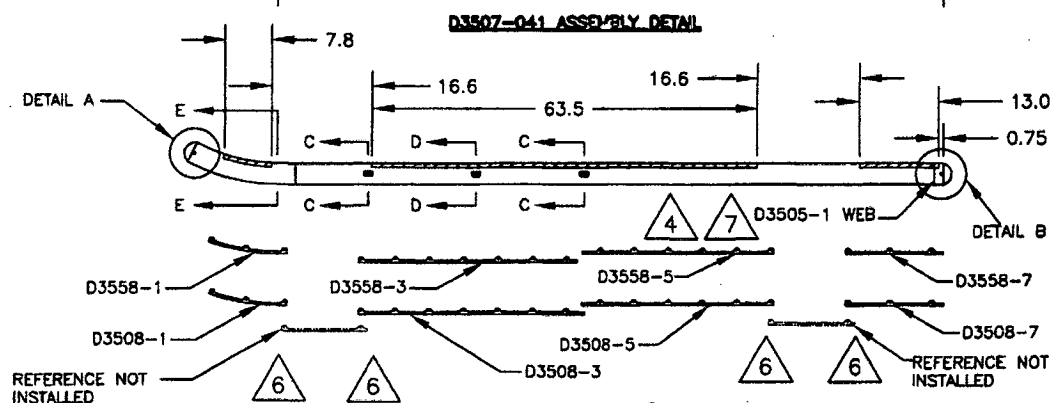
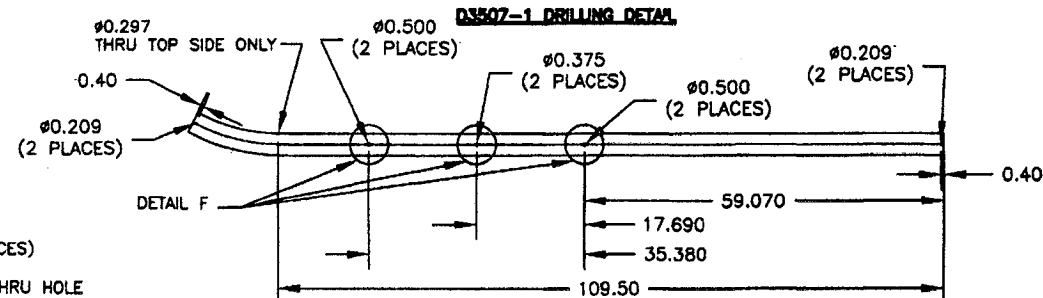
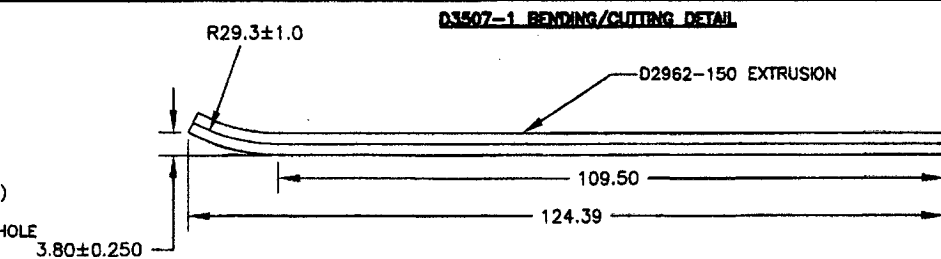
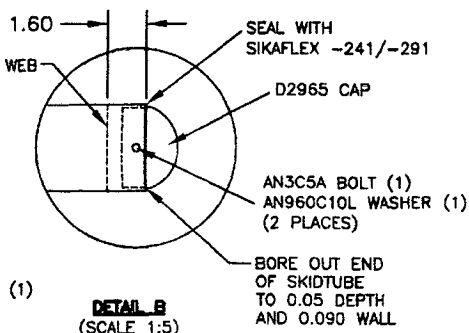
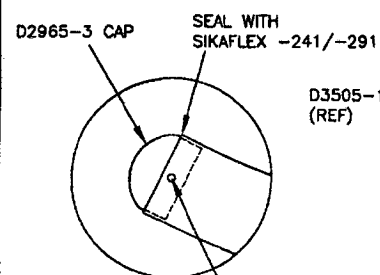
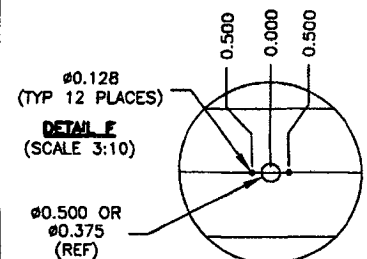
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- AFTER BENDING AND DRILLING ASSEMBLY PERFORM THE FOLLOWING FOR #0.500 HOLES ONLY:
1. CHAMFER HOLE 0.030 x 45°
 2. INSERT D3504-1 CROSS BOLT SPACER (2 PLACES)
 3. WELD INTO PLACE AND GRIND FLUSH
 4. IF REQUIRED, PASS #0.404 ("Y" DRILL) THROUGH HOLE
 5. INSTALL D3506-1 DOUBLER (4 PLACES) USING MS20601AD4W3 RIVET (8 PLACES)
 6. AFTER FINISH, INSTALL D3492-041 PLUG ASSEMBLY (4 PLACES)



- AFTER BENDING AND DRILLING ASSEMBLY PERFORM THE FOLLOWING FOR #0.375 HOLES ONLY:
1. CHAMFER HOLE 0.030 x 45°
 2. INSERT D3504-3 CROSS BOLT SPACER (1 PLACES)
 3. WELD INTO PLACE AND GRIND FLUSH
 4. IF REQUIRED, PASS #0.277 ("J" DRILL) DRILL THRU HOLE
 5. INSTALL D3506-3 DOUBLER (2 PLACES) USING MS20601AD4W3 RIVET (4 PLACES)
 6. AFTER FINISH, INSTALL D3492-047 PLUG ASSEMBLY (2 PLACES)



RELEASED
06.12.12

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DATE 06.11.01		TITLE EC 135 SKIDTUBE ASSEMBLY		SCALE 1:20			

DART AEROSPACE LTD		Work Order:	
Description: EC 135 SKIDPUKE		Part Number:	D3507-041
Inspection Dwg: D3507 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Bending	124.39	± 0.030	124.39				
	109.50	± 0.030	109.50				
	3.80 3.85	± 0.250	3.80				
Drilling	0.40	± 0.030	0.40				
	0.40	± 0.030					
	59.070	± 0.010	59.070				
	17.690	± 0.080	17.690				
	35.380	± 0.010	35.380				
	109.50	± 0.010	109.50				
Detail F	0.500	± 0.010					
Detail B	1.600	± 0.030					
	0.05	± 0.030					

Measured by:		Audited by:		Prototype Approval:	
Date:		Date:		Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

